



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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RBW6205G03532-3G

Job Sheet 199235



Part No: RBW6205G03532-3G

Job Qty: 1 pcs

Part Name: Main Rotor Blade Trim Tab Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/15/19

Job Tracking No:

Due Date: 9/17/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG RBW6205G03532-3G Rev.3 IPP Rev. A 18.10.10 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
95	Small Fab - Issue SN	1 pcs	9/17/19		0.00	0.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
100	Small Fab - 2 - B4B	1 pcs	9/17/19		0.00	0.20	Small Fab - 1 - B4B		MLL
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
							Small Fab - 8 - B4B		
110	QC 5	1 pcs	9/17/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		



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Container No: S211926



Part: RBW6205G03532-3G

Job No: 199235

Serial No/Batch: S211926

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 09/06/19

Plex 8/15/19 10:02 AM Dart.lajeunesse.marie

130 Packaging 3-1 - Stock - B4B 1 pcs	9/17/19	0.00 0.00	QC 5 - 30	SEP 05 2019	DAS 40 9-89
			QC 5 - 40		
			QC 5 - 61		
			QC 5 - 81		
			Packaging 3 - 1 - B4B		
			Packaging 3 - 2 - B4B		
			Packaging 3 - 3 - B4B		
			Packaging 3 - 4 - B4B		
			Packaging 3 - 5 - B4B		
			Packaging 3 - 6 - B4B		
			Packaging 3 - 7 - B4B		
			Packaging 3 - 8 - B4B		
			Packaging 3 - 9 - B4B		
			Packaging 3 - 10 - B4B		
			Packaging 3 - 11 - B4B		
			Packaging 3 - 12 - B4B		
			Packaging 3 - 13 - B4B		
			Packaging 3 - 14 - B4B		
			Packaging 3 - 15 - B4B		
			Packaging 3 - 16 - B4B		
			Packaging 3 - 17 - B4B		
			Packaging 3 - 18 - B4B		
			Packaging 3 - 19 - B4B		
			Packaging 3 - 20 - B4B		
			Packaging 3 - 21 - B4B		
			Packaging 3 - 22 - B4B		
			Packaging 3 - 23 - B4B		
			Packaging 3 - 24 - B4B		
			Packaging 3 - 25 - B4B		
			Packaging 3 - 26 - B4B		
			Packaging 3 - 27 - B4B		
			Packaging 3 - 28 - B4B		
			Packaging 3 - 29 - B4B		
			Packaging 3 - 30 - B4B		
			Packaging 3 - 31 - B4B		
			Packaging 3 - 32 - B4B		
			Packaging 3 - 33 - B4B		
			Packaging 3 - 34 - B4B		
			Packaging 3 - 35 - B4B		
			Packaging 3 - 36 - B4B		
140 QC 21 - FG	1 pcs	9/17/19	0.00 0.00	QC 21 - FG - 21	DAS 21 9-30 SEP 09 2019 RBOOIA
				QC 21 - FG - 70	
				QC 21 - FG - 53	

Part Op 95 - 1-Issue S/N.

Descriptions: 100 - 1-Glue placard RBW6205G03532-3G-13 to RBW6205G03532-3G-11 foam as per DWG. 2-Glue foam to case and pack case as per DWG.

110 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1550-E	Case	1 Ea (1 ea)	95-Small Fab - Issue SN	5128246
RBW6205G03532-3G-11	Lid Foam use in case APP-1550-E	1 Ea (1 ea)	100-Small Fab - 2 - B4B	5128247
RBW6205G03532-3G-13	Inside Placard	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5165740
RBW6205G03532-3G-9	Bottom Foam use in case APP-1550-E	1 Ea (1 ea)	100-Small Fab - 2 - B4B	5128249
RBW6205G03632-3G	Main Rotor Trim Tab Bending Tool	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5175307
RBW6205G03731-3G	Trim Tab Bending Gauge Assembly	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5174047
RBW6205G03832-3G	Main Rotor Blade Blocking/Protecting Assembly	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5178094

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
95-Small Fab - Issue SN 100-Small Fab - 2 - B4B	APP-1550-E	1	13	0
	RBW6205G03532-3G-11	1	2	0
	RBW6205G03532-3G-13	1	3	0
	RBW6205G03532-3G-9	1	2	0
	RBW6205G03632-3G - PS	1	1	0
	RBW6205G03731-3G - PO	1	0	0
	RBW6205G03832-3G - PB	1	0	0
Part Specifications				
Specifications could not be found.				

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REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED WELDMENT AND RE-ORGANIZED PRINTS. CHANGED -2 & -3 THICKNESS FROM .364 TO .375, AND CHANGED -36 & -41 FROM #1.045 TO #1.00.	2/20/06	WP	
2	DELETED -5 RETAINER AND CHANGED -7 TO A BUY OUT. REMOVED COUNTER BORES FOR HEX HEAD SCREWS AND #10-32 HOLES FOR -5 RETAINER. CHANGED #1/4 HOLES TO 1/4-28 UNF. ALSO CHANGED -9 HEX SCREW TO STUD W/LOCITE. ALSO CHANGED FROM POWDER COAT YELLOW TO PRIME AND PAINT.	5/12/06	WP	DW
2A	ADDED 7/16 TO INSIDE PLACARD, CH'D -13 FROM FOAM TOP TO INSIDE PLACARD, CH'D -11 FROM FOAM TOP TO LD FOAM, CH'D -11 CUTOUT TO RECESS FOR -13 PER R.W.	3/28/11	RJC	
2B	ADDED -36 TO ALL TOOL NUMBERS & ON -13 PER R.W.	5/11/11	RJC	RW
3	-8 CH'D DEPTH DIM WAS 4.00 IS 4.30, HEIGHT DIM WAS 5.25 IS 5.85, CORRECTED BOM. -11 ADDED CUTOUT FOR CLEARANCE, CH'D DEPTH OF PLACARD CUTOUT WAS .06 IS .125, CH'D SIZE OF PLACARD CUTOUT TO ACCOMMODATE NEW SIZE, CH'D FOAM WAS C200 IS Y-20. -13 ADDED PLACEMENT DIAGRAM TO PLACARD.	2/7/13	BM	JG

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WORK ORDER

NO. 199235 MLC
19-08-15

NOTES

1. RBW6205G03532-3G KIT CONTAINS THREE TOOLS, NUMBERED RBW6205G03632-3G AND RBW6205G03731-3G AND RBW6205G03832-3G.
2. FUNCTION: USED FOR MAIN ROTOR BLADE TRIM TAB BENDING.

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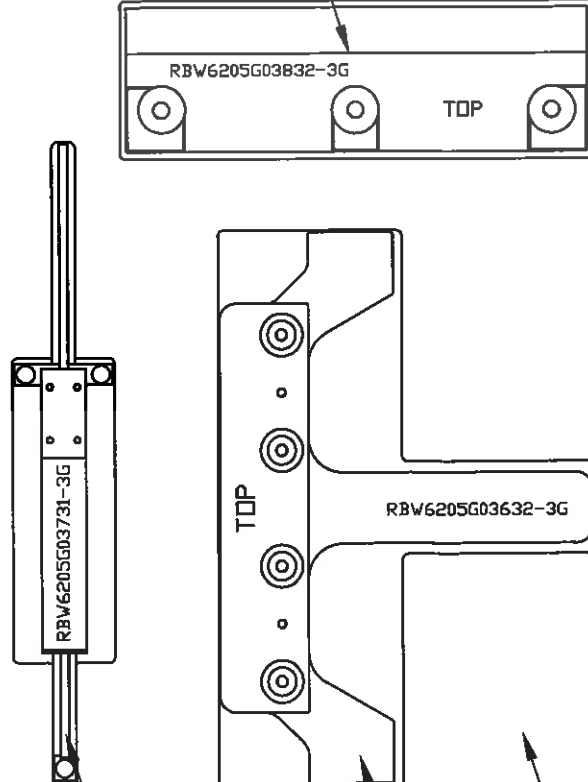
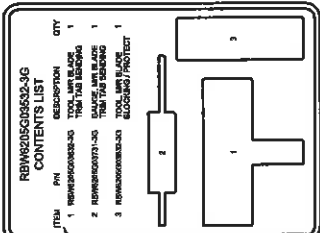
ORIGINAL No. REF.

KIT No. TOOL No. ORIGINAL No.

RBW6205G03532 = RBW6205G03532-3G = 3G6205G03632
 RBW6205G03532 = RBW6205G03632-3G = 3G6205G03632
 RBW6205G03532 = RBW6205G03731-3G = 3G6205G03731
 RBW6205G03532 = RBW6205G03832-3G = 3G6205G03832

DO NOT USE, FOR REFERENCE ONLY.

RED BARN MACHINE	
TITLE MAIN ROTOR BLADE TRIM TAB TOOL KIT	
DWG NO. RBW6205G03532-3G	REV 3
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	FRACTIONS ± 1/32
.XXX ± .005	ANGLES ± .5°
.XX ± .01	
.X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 2. DIMENSIONAL UNITS APPLY AFTER PLATING	
DRAWN BY: MARTINEZ	APPROVED: <i>D. Martinez</i>
HEAT TREAT SPEC	USED ON MODEL
AV139	REF. 3G6205G03532
DATE 1/15/09	SHEET 1 of 4



-13

-11

-3

-1

-9

-5



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			